

Work Order ID 163165

163165

Thursday, June 22, 2017 10:17:00 AM

Item ID: D350-636-011 Accept *N9000040100* Setup Start *NS1
 Revision ID: Stop *NS2*
 Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.
 Start Date: 6/22/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/5/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: DAS Date: JUN 22 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2750-041	G

100 Document Control
 100 DOCUMENT CONTROL

DC
 Doc.Control -USB or Paperwork

Memo
 record fwd angle:

Photocopy blue file and type labels per PPP D350-636-011_CHG 007

AUG 03 2017

DAS
 6
 0.00 9-89

0.00

89.9°

DAS
 28
 9-89

AUG 03 2017

17.02-12
 DZ

B163165 Ltr

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Thursday, June 22, 2017 10:17:00 AM

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Stop *NS2*

Start Date: 6/22/2017 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

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QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

110

Skidtubes

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B)

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

8-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

1 0 170626

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Start Date: 6/22/2017 Start Qty: 1.00

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Required Date: 7/5/2017 Req'd Qty: 1.00

1

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Reference:

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

A/R Aluminum Rod batch: M136158 / M136920 BE 17-06-26
9-Grind welds flush as per Dwg D2750

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

DAS
38
9-89

JUL 04 2017

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.02

Quality Control

DAS
38
9-89

JUL 04 2017

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Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.70							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.01							
Quality Control									

1 17-07-05
21
DAS
18
9-30
1 17-07-06

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NR2

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160

0.00

160

Skidtubes

Skidtubes

Skidtubes

Memo

1.08

1-Open up holes using hole saw of Detail C and ground handling to 0.625"
(total of 8 holes per side)
as per dwg D2750.

2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole using un-bit to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI015, let cure for 12hrs.

A/R Sikaflex-291

batch: M137526

exp. date: 18-04-21

11:00am

ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod

batch: M137133

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

17-07-06
Dg.

> 17-07-11

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D275012-Deburr holes, ensure tube is free of all scratches before sending to
paint.

170

QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo 0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo 0.02

Quality Control

VERIFY C'BOARD IS GOOD

17.07-1027

DAS
38
9-89

JUL 21 2017

DAS
38
9-89
JUL 21 2017

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Reference:

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
190	HandFinish	0.44				(X1)			2017/07/28
Hand Finishing	Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								BEB.
200	Spray Painting per QSI005 4.2	0.00							
200	SprayPaint	0.34				1			DAS 41 9-89
Spray Painting	Memo 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>137195</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>137852</u>								JUL 30 2017
210	QC14- Inspect Spray Paint	0.00							
210	QC	0.00				114			DAS 15 9-89
Quality Control	Memo Inspect for foreign object per QSI 024								

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* HandFinish Hand Finishing	Assemble as per dwg HandFinishing Memo 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M137946</u> EXP DATE: <u>18103</u> RTU 598 M137797 R/OC 4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M135477</u> 5- Coat all exposed fasteners with "LPS Procyon" batch: <u>M133690</u>	0.00 1.32							
240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Quality Control	0.00 0.02							

DAS

38

0.99

AUG 03 2017

Page 10

100* Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
		DAS 21 9-89		AUG 03 2017

AUG 03 2017

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC IPP REV:R 13.08.27 PER ECN13-594 DD
 VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1		Manufactured	No			230	Each	144.0000	8	8			
D3492-1									**			17/08/01	
Plug													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				144					
				158389				1					
				159298				63			X7		
				161306				80			X1		
D3492-3		Manufactured	No			230	Each	218.0000	8	8			
D3492-3									**			17/08/01	
Plug													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				218					
				159296				136					
				162347				82			X8		

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

203.0000

8

8

NAS1611-010

O-RING

**

12/08/01

Location

Loc Qty

Loc Code

FP001

203

m134955

7

m135603

8

m136182

4

m136836

84

m137587

100

VB

NAS1149D0863J

Purchased

No

250

Each

264.0000

2

2

NAS1149D0863J

Washer

**

AUG 03 2017

DAS

DAS

26

9-89

6

9-89

Location

Loc Qty

Loc Code

FP001

46

125484

46

ST260a

100

125635

100

ST263

118

125268

118

2

D2744

Manufactured

No

110

Each

20.0000

1

1

D2744

Cap

**

06-17-06-27

Location

Loc Qty

Loc Code

LG001

20

159371

10

161732

10

1

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT-LH

Manufactured No

110

Each

3.0000

1

1

D2600-3-BENT-LH

Extrusion Bent LH

**

BE170626

Location

Loc Qty

Loc Code

LG002

3

158771

3

1

D2743

Manufactured No

160

Each

172.0000

8

8

D2743

Crossbolt Spacer

**

BE170711

Location

Loc Qty

Loc Code

LG001

172

159308

62

8

160400

110

D2739

Manufactured No

160

Each

11.0000

1

1

D2739

350 I Beam

**

17-07-06

Location

Loc Qty

Loc Code

LG002

11

159936

3

161380

8

1

D3490-3

Manufactured No

160

Each

83.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE170711

Location

Loc Qty

Loc Code

LG001

83

160393

83

4

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

95.0000

4

4

D3490-1

Cross Bolt Spacer

**

861707-11

Location

Loc Qty

Loc Code

LG001

95

60394

95

4

ALS4-1032-225

AELS8-1032-225

Purchased

No

160

Each

2,629.000

38

38

ALS4-1032-225

Rivnut

**

all 12/08/01

Location

Loc Qty

Loc Code

FG

25

M134975

20

M135998

5

FP001

2204

M135603

40

M135920

38

M135998

2115

M136265

11

138

ST556

400

M136579

400

D3793-3

Manufactured

No

230

Each

29.0000

1

1

D3793-3

Wearplate Aft

**

all 12/08/01

Location

Loc Qty

Loc Code

FP002

29

159397

4

159871

25

X

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Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

124.0000

1

1

AN8C35A

Bolt

**

all 17/08/01

Location

Loc Qty

Loc Code

FG

3

121275

3

FP001

121

m133336

1

m134130

1

m134133

7

m137203

112

X1

D3793-1

Manufactured

No

230

Each

26.0000

1

1

D3793-1

Wearplate Fwd

**

all 17/08/01

Location

Loc Qty

Loc Code

FP002

26

159358

4

159874

22

X1

D3488-041

Manufactured

No

230

Each

2.0000

1

1

D3488-041

Blade Fitting LH

**

all 17/08/01

Location

Loc Qty

Loc Code

FP001

2

158789

2

13162409

X1

D3794-3

Manufactured

No

230

Each

13.0000

1

1

D3794-3

Gasket Aft

**

all 17/08/01

Location

Loc Qty

Loc Code

FP001

13

159369

12

159924

1

13163320

X1

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

376.0000

4

4

AN6C44A

Bolt

**

lll 12/08/02

Location

Loc Qty

Loc Code

FP001

78

m132556

78

over009

250

m137055

250

ST333

48

m136658

48

XU

MS21083C8

Purchased

No

230

Each

63.0000

1

1

MS21083C8

Nut

**

lll 12/08/02

Location

Loc Qty

Loc Code

FP001

18

m137412

18

ST297

45

m137361

25

m137820

20

X1

D3536-25

Manufactured

No

230

Each

27.0000

1

1

D3536-25

Gasket Center

**

lll 12/08/02

Location

Loc Qty

Loc Code

FG

3

95328

3

FP001

24

146747

2

159368

4

162506

18

X1

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Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230

Each

159.0000

8

8

D3631-1

Washer

**

all 17/08/01

Location

Loc Qty

Loc Code

FP001

159

159502

59

160124

100

x8

D3791-1

Manufactured No

230

Each

20.0000

1

1

D3791-1

Wearpad

**

all 17/08/01

Location

Loc Qty

Loc Code

FP002

20

158753

10

161928

10

x1

NAS1149C0332R

Purchased No

230

Each

4,974.000

38

38

NAS1149C0332R

WASHER

**

all 17/08/01

Location

Loc Qty

Loc Code

FP001

1470

m137597

1470

M137951

x38

GA

508

m133284

22

m136444

486

ST260a

2000

m135408

0

m136741

0

m137851

2000

ST266

996

m137381

996

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Required Qty: 1.00

D2745

Manufactured No

230

Each

182.0000

8

8

D2745

Bushing

**

el 12/08/01

Location

Loc Qty

Loc Code

FP001

182

159297

82

161760

100

x8

AN3C5A

Purchased

No

230

Each

928.0000

34

34

AN3C5A

Bolt

**

el 12/08/01

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

657

M137361

657

x34

OVER002

200

M137710

200

ST350

66

M135442

66

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Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

162.0000

3

3

D3537-1

Wearpad

**

ll 12/08/01

Location

Loc Qty

Loc Code

FG

11

B163518

79833

1

x2

88562

10

B162601

x1

FP001

151

141922

7

147593

5

154226

1

159356

38

161530

50

161531

50

NAS1149C0832R

Purchased

No

230

Each

49.0000

1

1

NAS1149C0832R

Washer

**

ll 12/08/01

Location

Loc Qty

Loc Code

FP001

49

m135536

49

x1

Picklist Print

Thursday, June 22, 2017 10:17:04 AM

Work Order ID: 163165

163165

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 147.0000 4 4

AN3C6A

Bolt

**

lll 12/08/01

Location	Loc Qty	Loc Code	
FG	10		
122416	10	M138040	x4
FP001	21		
m136295	4		
m136781	17		
OVER002	96		
m137361	96		
ST350	20		
m128704	18		
m132767	2		

NAS1611-013 Purchased No 230 Each 174.0000 8 8

NAS1611-013

O-Ring

**

lll 12/08/01

Location	Loc Qty	Loc Code	
FP001	174		
m137333	174		x8

D3535-25 Manufactured No 230 Each 18.0000 1 1

D3535-25

Wearplate Center

**

lll 12/08/01

Location	Loc Qty	Loc Code	
FG	1	B162506	
148669	1		x1
FP002	17		
159879	7		
161915	10		x1

Picklist Print

Thursday, June 22, 2017 10:17:04 AM

Work Order ID: 163165

163165

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

15.0000

1

1

D3794-1

Gasket Fwd

**

all 13/08/01

Location

Loc Qty

Loc Code

FP001

15

142770

1

150417

2

159376

12

X

MS21043-6

Purchased No

230

Each

72.0000

4

4

MS21043-6

NUT

**

all 13/08/01

Location

Loc Qty

Loc Code

FG

20

103693

20

1137963

X

FP001

12

m135470

2

m137361

10

ST302

40

m137479

40

D3493-1

Manufactured No

250

Each

39.0000

2

2

D3493-1

Washer

**

DAS 6
AUG 03 2017 9-89

DAS 26
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST037

29

159305

9

161754

20

163466

DAS 28
9-89

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

Picklist Print

Thursday, June 22, 2017 10:17:04 AM

Work Order ID: 163165

163165

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

63.0000

2 2

MS21083C8

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

18

m137412

18

ST297

45

m137361

25

m137820

20

**

AUG 03 2017 DAS
6
9-89

AN8C21A

Purchased

No

250

Each

302.0000

2 2

AN8C21A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

4

123966

2

m132169

2

over004

217

m137162

217

ST332

81

m136262

1

m137162

80

**

AUG 03 2017 DAS
6
9-89

Picklist Print

Thursday, June 22, 2017 10:17:04 AM

Work Order ID: 163165

163165

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

403.0000

4

4

***NAS1515H3I ***

Washer

**

all washer

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

359

m127831

20

m134508

3

m135600

2

m136263

4

m137361

330

ST266

4

X4

m130726

4

D2741

Manufactured

No

250

Each

47.0000

1

1

D2741

Replacement Blade

**

AUG 03 2017

DAS

DAS

26

9-89

Location

Loc Qty

Loc Code

FG

10

131616

10

ST538

37

132981

14

158915

23

D3532-1

Manufactured

No

250

Each

45.0000

2

2

D3532-1

Spacer

**

AUG 03 2017

DAS

DAS

26

9-89

Location

Loc Qty

Loc Code

ST038

45

159312

45

2

DAS

28

9-89

DAS

6

9-89

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER
NO. *163165 MJS*
170622

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2013-08-13
WD

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1/-4/-5/-6/-7); UPDATED FINISH OPTIONS, INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DED 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY

REV. G
SHEET 1 OF 11
SCALE
NTS

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8 7 6 5 4 3 2 1

D

D

C

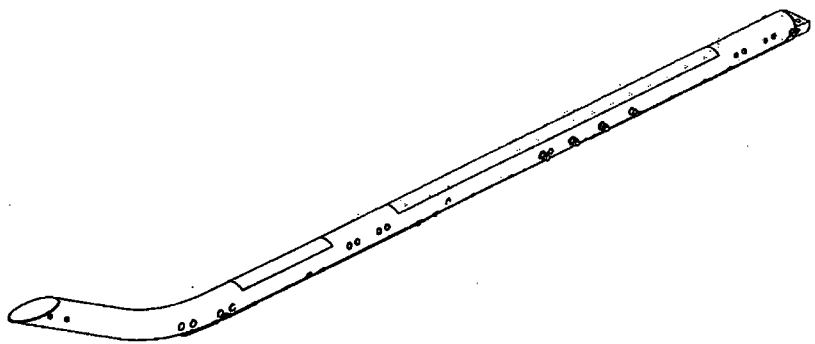
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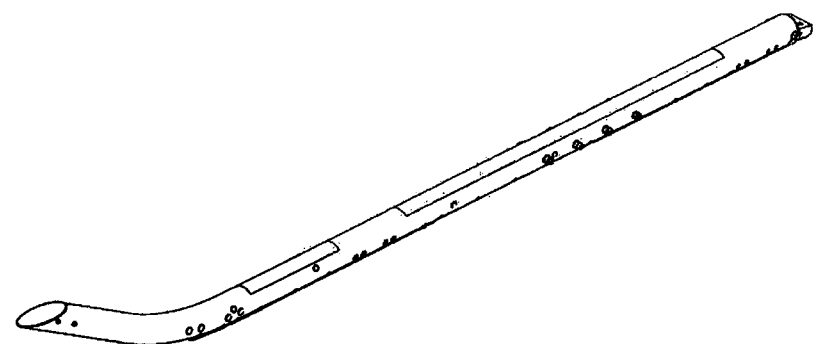
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A

A



D2750-041 350 SKIDTUBE ASSEMBLY, LH

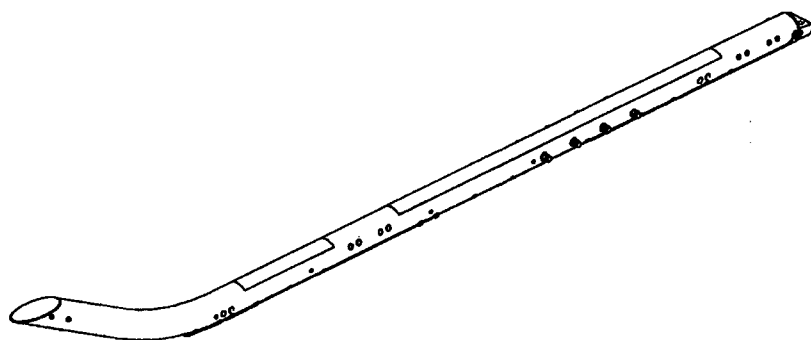


D2750-042 350 SKIDTUBE ASSEMBLY, RH

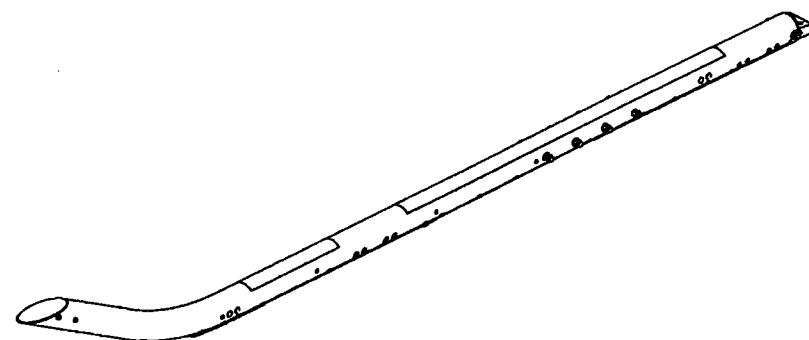
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2013-08-13
MD

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CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 2 OF 11	
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2



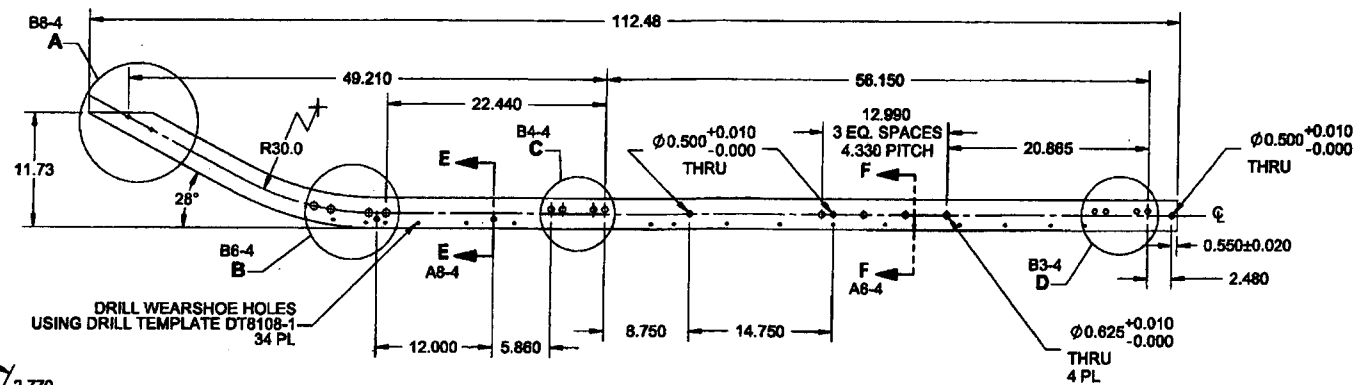
D2750-043 350 SKIDTUBE ASSEMBLY, LH



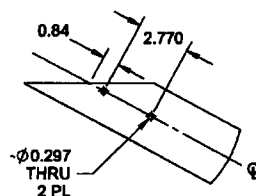
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13

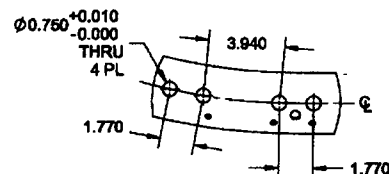
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MFG. APPR.		D2750	SHEET 3 OF 11
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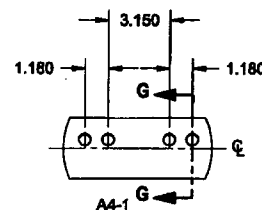
D2750-1 LH SKIDTUBE



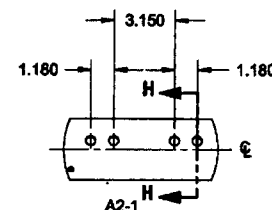
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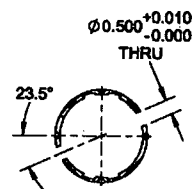
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SCALE 2X



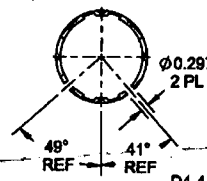
DETAIL C
SCALE 2X



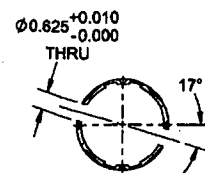
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SCALE 2X



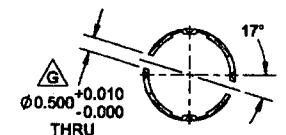
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



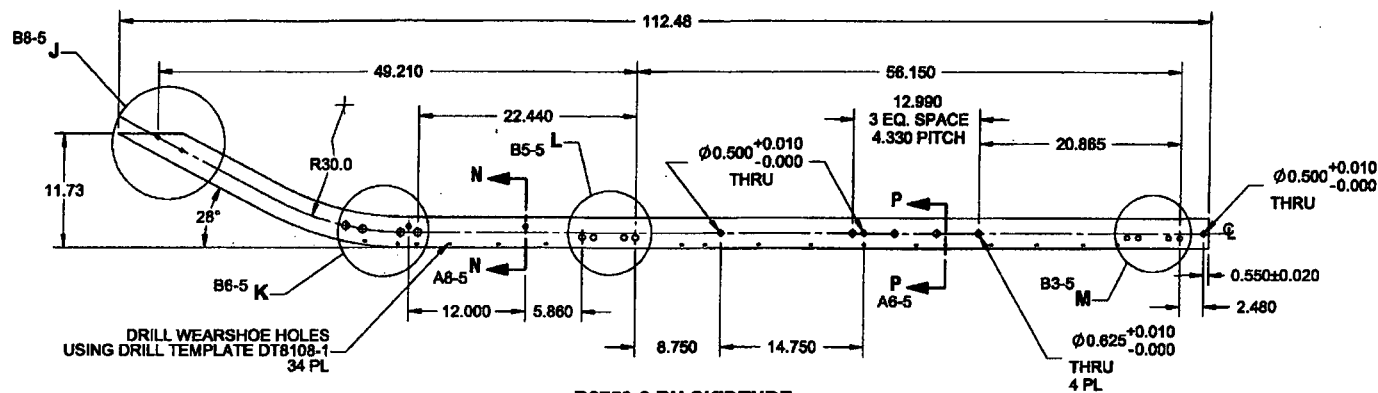
SECTION G-G
SCALE 3X, 4 PL



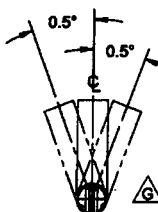
SECTION H-H
SCALE 3X, 4 PL

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OE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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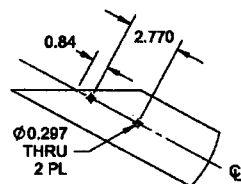


D2750-2 RH SKIDTUBE

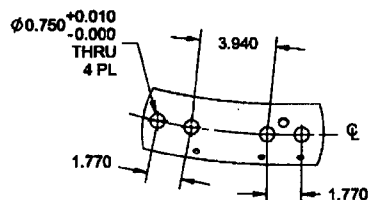


OUTBD

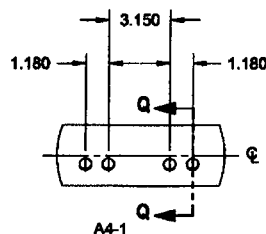
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



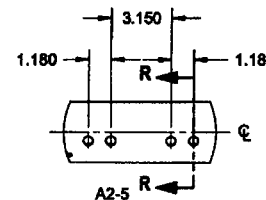
DETAIL J
SCALE 2X



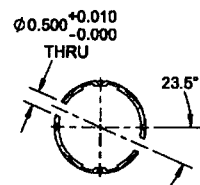
DETAIL K
SCALE 2X



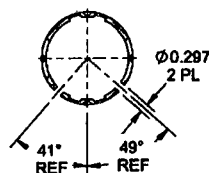
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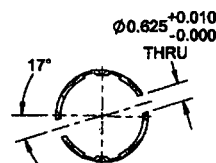
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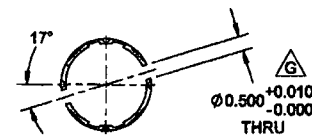
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SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



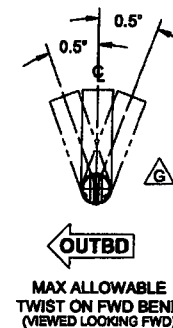
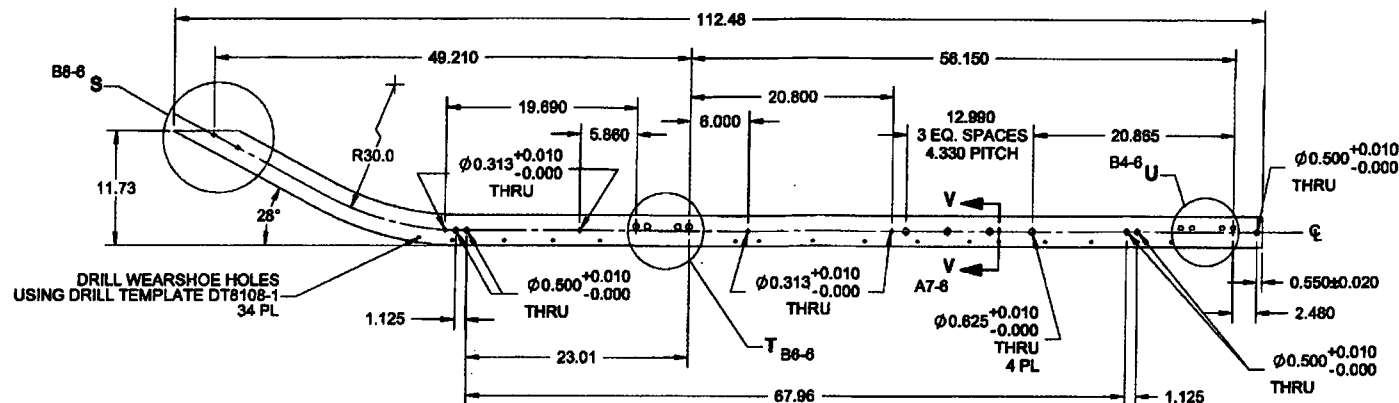
SECTION Q-Q
SCALE 3X, 4 PL



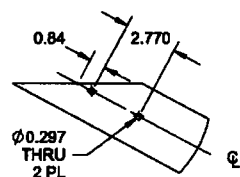
SECTION R-R
SCALE 3X, 4 PL

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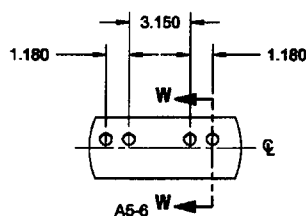
DESIGN	MM	DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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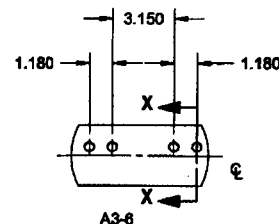
D2750-3 LH SKIDTUBE



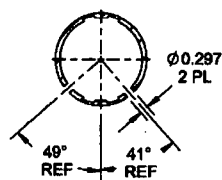
DETAIL S
SCALE 2X



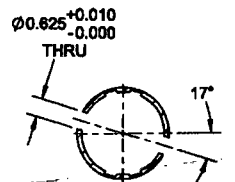
DETAIL T
SCALE 2X



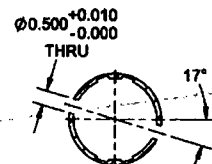
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



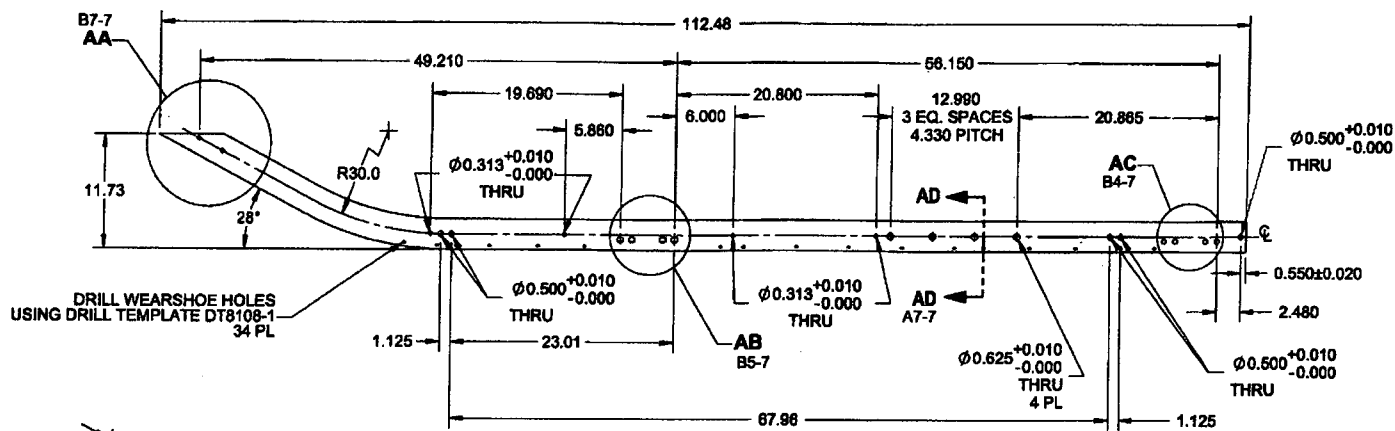
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SCALE 3X, 4 PL



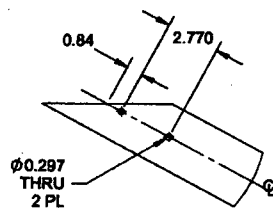
SECTION X-X
SCALE 3X, 4 PL

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2013-08-13

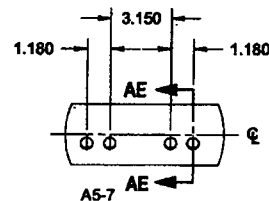
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
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MFG. APPR.		D2750	SHEET 8 OF 11
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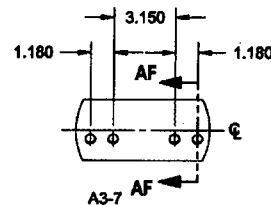
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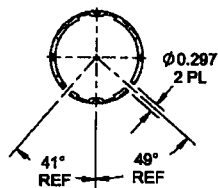
DETAIL AA
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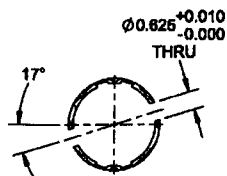
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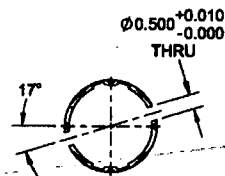
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



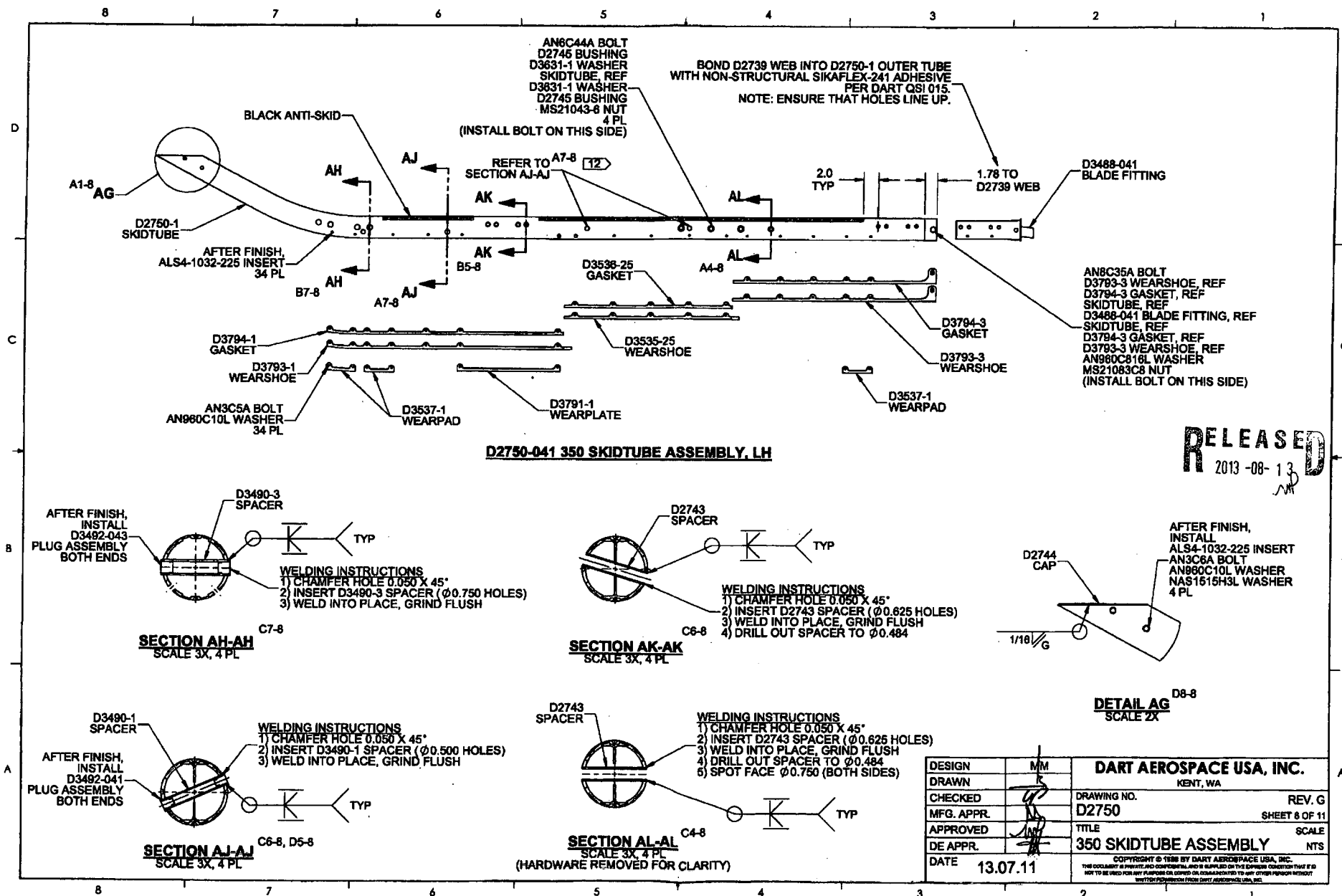
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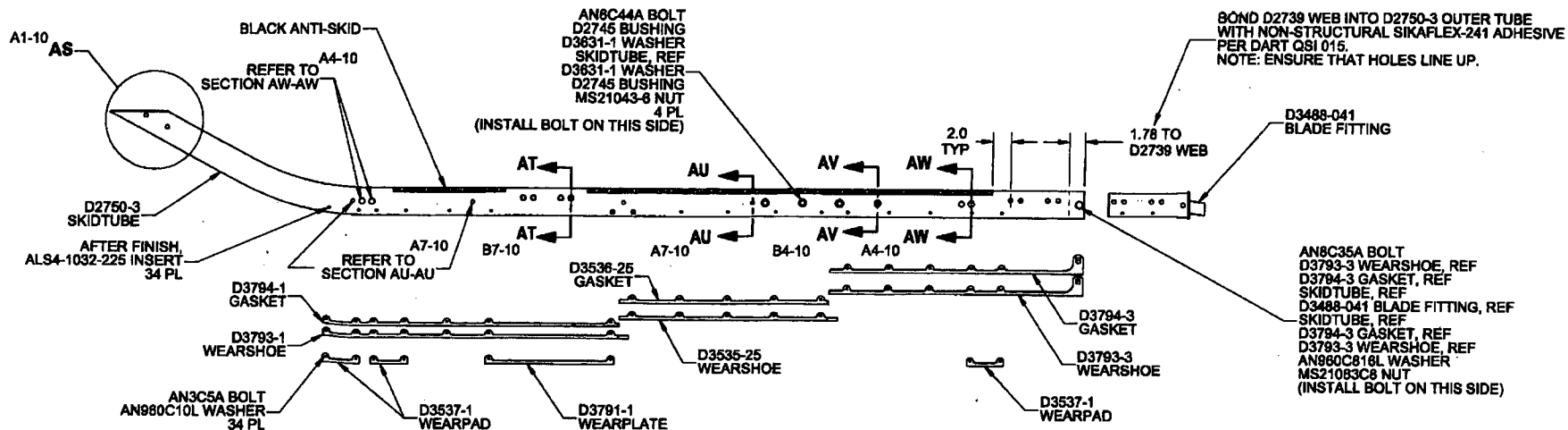


SECTION AF-AF
SCALE 3X, 4 PL

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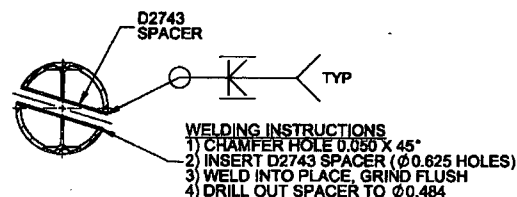
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

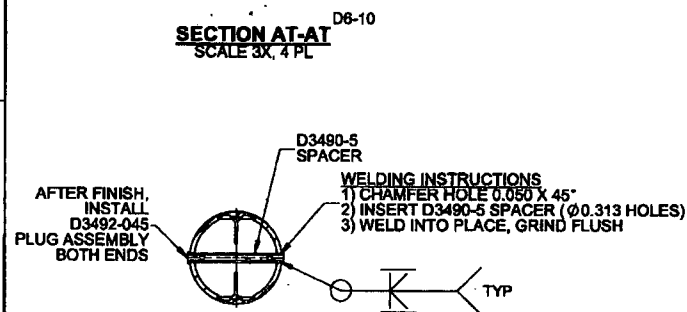
RELEASE
2013-08-13



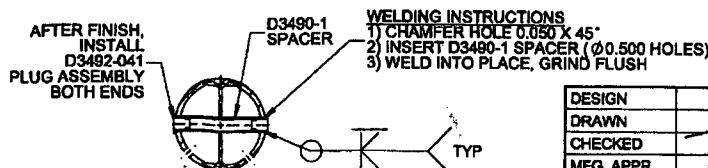
SECTION AT-AT SCALE 3X, 4 PL



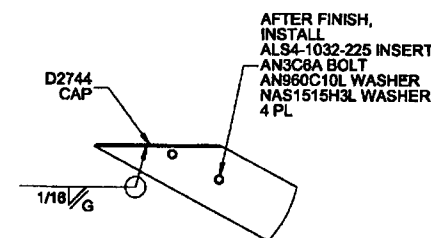
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SECTION AU-AU SCALE 3X, 4 PL



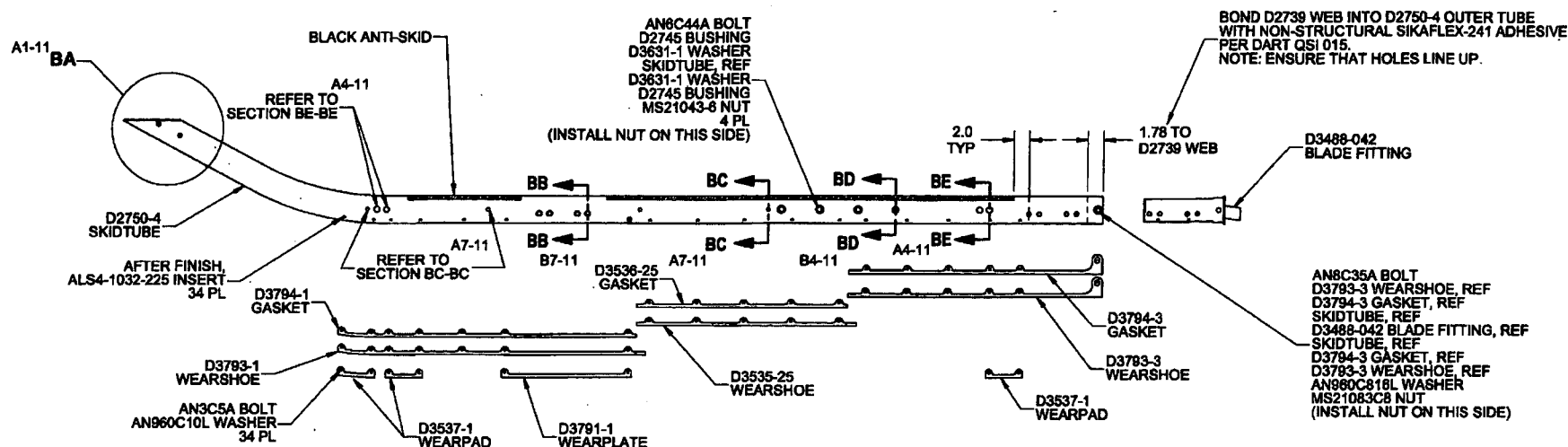
SECTION AW-AW SCALE 3X, 4 PL



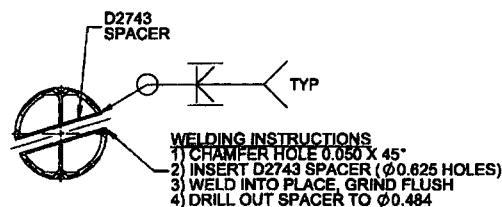
DETAIL AS SCALE 2X

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8 7 6 5 4 3 2 1



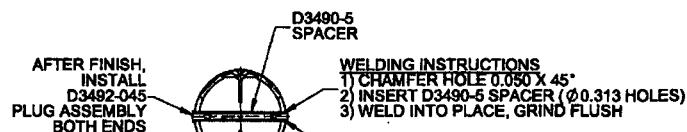
D2750-044 350 SKIDTUBE ASSEMBLY, RH



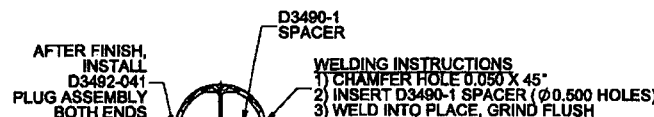
SECTION BB-BB SCALE 3X, 4 PL



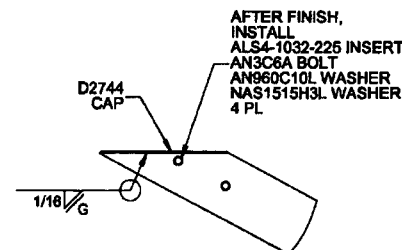
SECTION BD-BD SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC SCALE 3X, 4 PL



SECTION BE-BE SCALE 3X, 4 PL



DETAIL BA SCALE 2X

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RELEASED
2013-08-13

163165

Order ID 163165

ay, June 22, 2017 10:17:00 AM

Accept

N900040100

Setup Start *NS1
Stop *NS2*

ID: D350-636-011

Revision ID:

Item Name:

Skidtube LH, Std Wearplates. DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00

Required Date: 7/5/2017 Req'd Qty: 1.00

Cust Item ID:

Customer:

Run Start *NR1*
Stop *NR2*

Reference:

Approvals:

Process Plan:

Date: JUN 22 2017 Tooling:

Date:

Date: SPC (Y/N):

Date:

QC:

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D2750-041

G

AUG 03 2017

0.00

Document Control
DOCUMENT CONTROL

0.00

DAS
5
9-89

AUG 03 2017

17.08-1
DX

100
DC

Doc Control -USB or Paperwork

Memo
record fwd angle: 89.9

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

United States of America
Department of Transportation - Federal Aviation Administration

Supplemental Type Certificate

Number SR00646SE

This certificate, issued to

Dart Aerospace USA, Inc.
190 S. Danebo Ave.
Eugene, OR 97402

*certifies that the change in the type design for the following product with the limitations and conditions therefore as specified hereon meets the airworthiness requirements of Part * of the * Regulations.*

Original Product—Type Certificate Number:

Make:

Model:

* See attached Federal Aviation Administration (FAA) Approved Model List (AML) SR00646SE for approved aircraft models and applicable airworthiness regulations

Description of the Type Design Change: Replacement of the original landing gear skid tubes with DART D350-636 skid tube system components as appropriate. The D350-636 skid tube system must be fabricated in accordance with DART Aerospace USA, Inc. Master Document List (MDL) No. MDL-D350-636, Revision N, dated September 01, 2010, or later Federal Aviation Administration (FAA) approved Revision. The skid tubes must be installed in accordance with DART Aerospace Installation Instructions No. INN-D350-636, Revision H, dated July 26, 2010, or later FAA accepted revision. This modification must be maintained in accordance with DART Aerospace Instructions for Continued Airworthiness (ICA) No. ICA-D350-636, Revision 1, or later FAA-approved revision.

Limitations and Conditions: Approval of this change in type design applies to rotorcraft listed on the Approved Model List (AML) only. This approve should not be extended to other rotorcraft of these models on which other previously approved modification are incorporated unless it is determined by the installer that the relationship between this change and any of those other previously approved modifications, including changes in type design, will introduce no adverse effect upon the airworthiness of the rotorcraft.

A copy of this Certificate, AML No. SR00646SE, and the ICA must be maintained as part of the permanent records for the modified rotorcraft.

If the holder agrees to permit another person to use this certificate to alter the product, the holder shall give the other person written evidence of that permission.

This certificate and the supporting data which is the basis for approval shall remain in effect until surrendered, suspended, revoked, or a termination date is otherwise established by the Administrator of the Federal Aviation Administration.

Date of application: April 24, 1998

Date reissued: October 28, 2015

Date of issuance: November 19, 1998

Date amended: September 27, 2010



By direction of the Administrator

[Signature]
(Signature)

[Signature]
Manager, Seattle Aircraft Certification Office
(Title)

Any alteration of this certificate is punishable by a fine of not exceeding \$1,000, or imprisonment not exceeding 3 years, or both.

This certificate may be transferred in accordance with FAR 21.47.